

Work Order ID 151973

Friday, October 14, 2016 1:56:22 PM

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Page 1

Item ID: D205-634-041 **Accept** ***N900040100*** **Setup Start *NS1***
Revision ID: **Stop *NS2***
Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH
Start Date: 10/6/2016 **Start Qty:** 1.00 ***1*** **Cust Item ID:**
Required Date: 10/14/2016 **Req'd Qty:** 1.00 ***1*** **Customer:**
Reference:

Approvals: **Process Plan:** **DAS** **21** **Date:** OCT 17 2016 **Tooling:** **Date:** **Run Start *NR1***
QC: **9-89** **Date:** **SPC (Y/N):** **Date:** **Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2580-041	G

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG005								

N/A **DAS** **21** **9-89**

JAN 10 2017

110	BENDING MACHINE - SKIDTUBES	0.02							
110									
CNC Bend 1	Memo	0.07							
CNC Delta 100 Bender	1-Bend as per program D2580.C on CNC Bender and Folio 16								
	2-Cut tubes as per Dwg. D2580								
	3- scribe batch# in aft end of tube								

16-11-8

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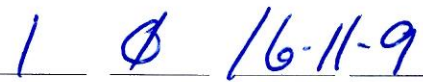
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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120									
Skidtubes	Memo	0.21							
Skidtubes	1- Deburr ends and remove bending marks								
	2- Prepare tube for welding as per QSI 004								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

16-11-09 DT. 

1 Ø 16-11-9 

DAS 19 2-00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
140									
Skidtubes		0.25							
Skidtubes	Memo 1-Weld step D2576 as per Dwg. D2580 and OSI 004 A/R Aluminum Rod <u>M133750</u> 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per OSI002 and trim/ grind flush per OSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x 17G to start expantion and finish with 1/2 x 18G to achieve dwg dimation. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web.Deburr 5-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr 6-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr 7-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr								
150									
150									
QC									
Quality Control	Memo QC10- Inspect visual per OSI004- ground welds	0.00							

Handwritten notes:
78E16-11-16
16-11-09
DT.89
16-11-17

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9
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									DAS
QC	Memo	0.00							9
Quality Control									9-89
170	Pressure Wash per QSI005 4.3	0.00							
170									
HandFinish	Memo	0.09							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.								
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
180									
Powdercoat	Memo	0.05							
Powder Coating	START TIME: 8:25 OVEN TEMPERATURE: 320 FINISH TIME: 8:55								

Handwritten notes and stamps:
- Under 160: (X1) 16-11-17
- Under 170: (X1) 2016/11/23 BEB
- Under 180: 1 16-12-12 333

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.00							
Quality Control									

12 d 10/12/12

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Item ID: D205-634-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 10/6/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/14/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00

200

HandFinish

Memo

0.26

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 M1136093
Sikaflex expire date: 1/7/19

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M1136093
Sikaflex expire date: 1/7/19

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M113620611 16/12/12

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Required Date: 10/14/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024	0.00 0.00				1			DAS 38 9-89 DEC 13 2016
220 *220* Packaging Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____	0.00 0.00							DAS 27 9-89 JAN 06 2017
230 *230* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.02							DAS 21 9-89 JAN 10 2017 DAS 21 9-89 JAN 09 2017

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Work Order ID: 151973

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 10/6/2016

Required Date: 10/14/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC IPP REV:R 12.01.23 AS
PER ECN11-684 VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1		Manufactured	No			140	Each	237.0000	20	20			

D4202-1

Spacer

Location

Loc Qty

Loc Code

LG001

237

145902

5

147952

232

D2580-1

Manufactured No

110

Each

0.0000

1

1

D2580-1

205 Bent Tube

D2576-3

Manufactured No

140

Each

96.0000

1

1

D2576-3

Step (Machining Detail)

Location

Loc Qty

Loc Code

LG001

96

144673

10

148337

36

151399

50

20 16-11-08 DT.
1 16-11-08 DT.

BE16-11-15

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Work Order ID: 151973

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 10/6/2016

Required Date: 10/14/2016

Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 200 Each 105.0000 1 1

D2855

Cap

all 10/12/17

Location

Loc Qty

Loc Code

FP001

105

137568

1

147805

104

AN3-5A

Purchased No

200 Each

280.0000

2

2

AN3-5A

Bolt

all 10/12/17

Location

Loc Qty

Loc Code

FP001

155

m134502

155

ST350

125

m135058

125

NAS1149D0332J

Purchased No

200 Each

1,213.000

2

2

NAS1149D0332.J

Washer

all 10/12/17

Location

Loc Qty

Loc Code

CA

6

m129682

6

FP001

196

m134848

196

GA

222

m134848

222

ST260a

600

m135672

600

ST264

189

m135536

31

m135566

158

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Shop Packet Print

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Work Order ID: 151973

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 10/6/2016

Required Date: 10/14/2016

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

AELS8-1032-130

Purchased

No

200

Each

609.0000

50

50

AI S7-1032-130

** ALS7-1032-130 / M135442*

650

all

10/12/12

Rivnut

Location

Loc Qty

Loc Code

FG

50

M128649

50

FP001

559

M128649

559

AN3C4A

Purchased

No

200

Each

1,801.000

50

50

AN3C4A

all

10/12/12

Bolt

Location

Loc Qty

Loc Code

FG

20

122814

20

FP001

460

M133440

7

M134396

41

M134509

6

M134606

29

M134676

44

M134762

106

M134861

13

M135058

140

M135127

22

M135297

52

OVER002

1300

M135442

500

M135704

250

M135774

250

M135864

300

ST350

21

M134134

7

M134396

14

M135440

M136295

x27

x23

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 10/6/2016

Required Date: 10/14/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

200

Each

4,147.000

50

50

NAS1149C0332R

WASHER

lll 10/12/12

Location

Loc Qty

Loc Code

FP001

526

m135274

526

11136194

x50

GA

86

m133284

86

ST260a

2000

m135466

1000

m135672

1000

ST266

1535

m129682

24

m134736

85

m135408

926

m135766

500

D3566-13

Manufactured

No

200

Each

22.0000

1

1

D3566-13

Gasket Fwd

lll 10/12/12

Location

Loc Qty

Loc Code

FG

2

98908

2

FP001

20

148070

8

151142

12

x1

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D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 10/6/2016

Required Date: 10/14/2016

Start Qty: 1.00

Required Qty: 1.00

D3566-5

Manufactured No

200

Each

26.0000

1

1

D3566-5

Gasket Center Aft

**

all 16/12/12

Location

Loc Qty

Loc Code

FG

4

139236

2

148071

2

FP001

19

147914

19

FP002

3

148071

3

x1

D3566-1

Manufactured No

200

Each

45.0000

2

2

D3566-1

Gasket Aft / Fwd

**

all 16/12/12

Location

Loc Qty

Loc Code

FG

8

117012

4

139221

4

FP001

37

139221

4

140819

1

149559

2

151476

14

151632

16

B154126

x2

D3564-11

Manufactured No

200

Each

11.0000

1

1

D3564-11

Wearplate Aft

**

all 16/12/17

Location

Loc Qty

Loc Code

FG

4

77056

4

FP002

7

148650

7

B152217

x1

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Start Date: 10/6/2016

Required Date: 10/14/2016

Start Qty: 1.00

Required Qty: 1.00

D3564-13

Manufactured No

200

Each

19.0000

1

1

D3564-13

Wearpad Fwd

**

del 10/12/16

Location

Loc Qty

Loc Code

FG
89044
FP001
147966
148702

2
2
17
11
6

B152299

xl

D3564-9

Manufactured No

200

Each

33.0000

1

1

D3564-9

Wearplate Fwd

**

del 10/12/16

Location

Loc Qty

Loc Code

FG
76950
88407
FP002
150310
151145

6
4
2
27
13
14

xl

D3564-5

Manufactured No

200

Each

15.0000

1

1

D3564-5

Wearplate Center

**

del 10/12/17

Location

Loc Qty

Loc Code

FG
34806
89048
FP002
147887

3
1
2
12
12

B152430

xl

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Work Order ID: 151973

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Parent Item: D205-634-041

D205-634-041

Parent Item Name: Replacement Skidtube with Standard Wearplates Fits LH or RH

Start Date: 10/6/2016

Required Date: 10/14/2016

Start Qty: 1.00

Required Qty: 1.00

D2594-3

Manufactured No

200

Each

562.0000

16

16

D2594-3

O-Ring

all 10/12/16

Location

Loc Qty

Loc Code

FP001

562

135859

24

138060

2

140770

2

145268

500

147875

34

x16

D2594-1

Manufactured No

200

Each

417.0000

16

16

D2594-1

Plug

all 10/12/16

Location

Loc Qty

Loc Code

FP001

417

119830

68

134804

16

146645

85

147564

1

147974

7

148319

105

150991

100

151587

3

42807

25

88922

7

B151971

x8

x8

LIST OF MATERIALS					PART NUMBER	DESCRIPTION
ITEM	QTY -041	QTY -045	QTY -047	QTY -049		
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2500-1-190	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2578-3	STEP
23		4			D2579	SPACER
24	16	16	8	8	D2594-1	PLUG
25	16	16	8	8	D2594-3	O-RING
26	1	1	1	1	D2596	205 WEB
27	1	1	1	1	D2855	AFT CAP
28	1	1			D3584-5	WEARSHOE
29	1	1			D3584-9	WEARSHOE
30	1	1			D3584-11	WEARSHOE
31	1	1			D3584-13	WEARSHOE
32	2	2			D3586-1	GASKET
33	1	1			D3586-5	GASKET
34	1	1			D3586-13	GASKET
35	20	20	24	24	D4202-1	SPACER
36			1		D4406-041	WEARPLATE ASSEMBLY
37			1		D4406-043	WEARPLATE ASSEMBLY
37				1	D5081-1	FWD WEARPLATE
37				1	D5081-3	AFT WEARPLATE
50	50	50			ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
51	50	50			AN3C4A	BOLT
52	2	2	2	2	AN3-5A	BOLT
53			8	8	AN4-45A	BOLT
54	50	50			NAS1149C0332R	WASHER (AN960C10L)
55	2	2	2	2	NAS1149D0332J	WASHER (AN960JD10L)
56			8	8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

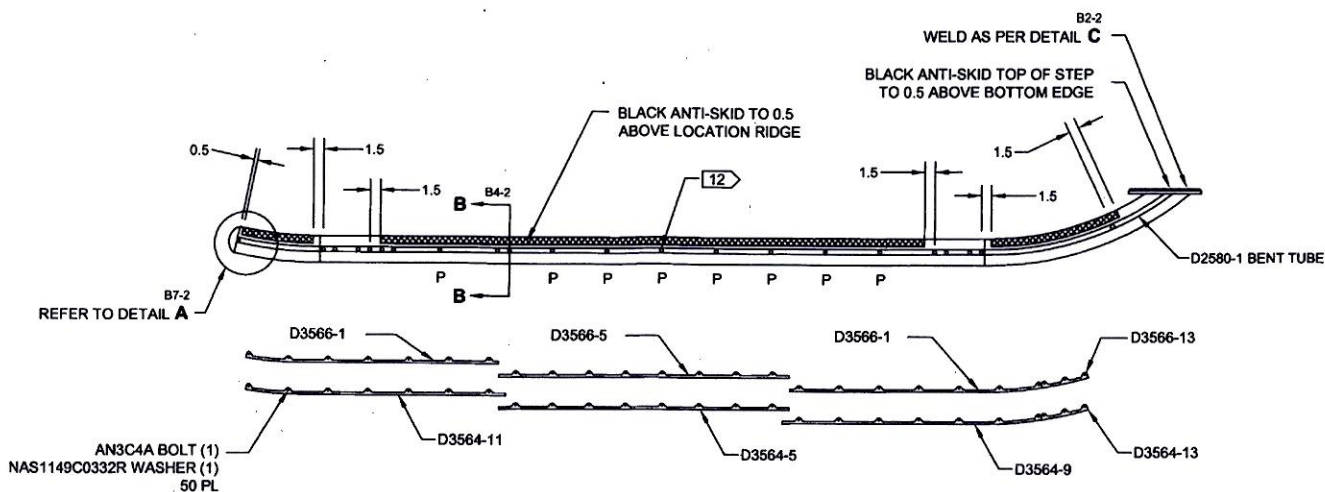
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3 POWDER COAT ASSEMBLY (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.4. BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 34.5 lbs
D2580-045 = 34.5 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 151973 MLS
16-10-17

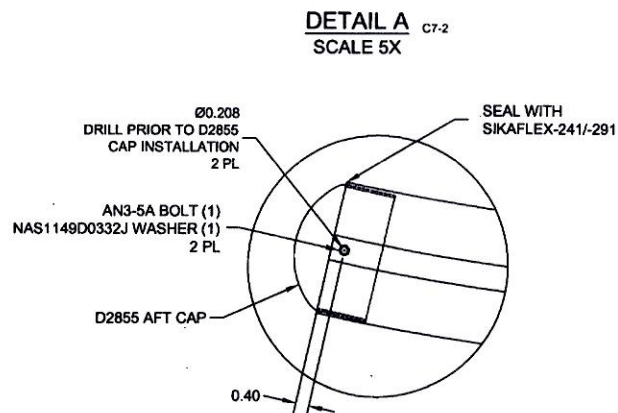
RELEASED
2014-04-29

G	ADDED -049, -047 WEIGHT UPDATED PER DSI 9598	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS: DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/ 9183	PH	07.04.05
C	REDRAWN, INCLUDED DEO 9094/ 9097	CP	98.08.28
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.	12	D2580	SHEET 1 OF 9
APPROVED	12	TITLE	SCALE
DE APPR.	12	205 SKIDTUBE ASSEMBLY	NTS
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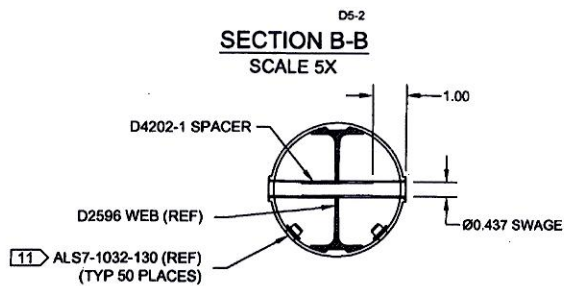


D2580-041 ASSEMBLY DETAIL

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2014-04-29

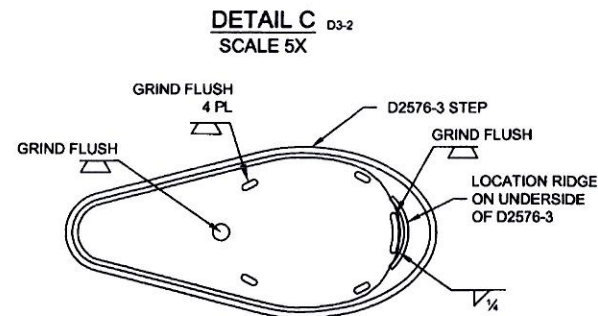


DETAIL A C7-2
SCALE 5X



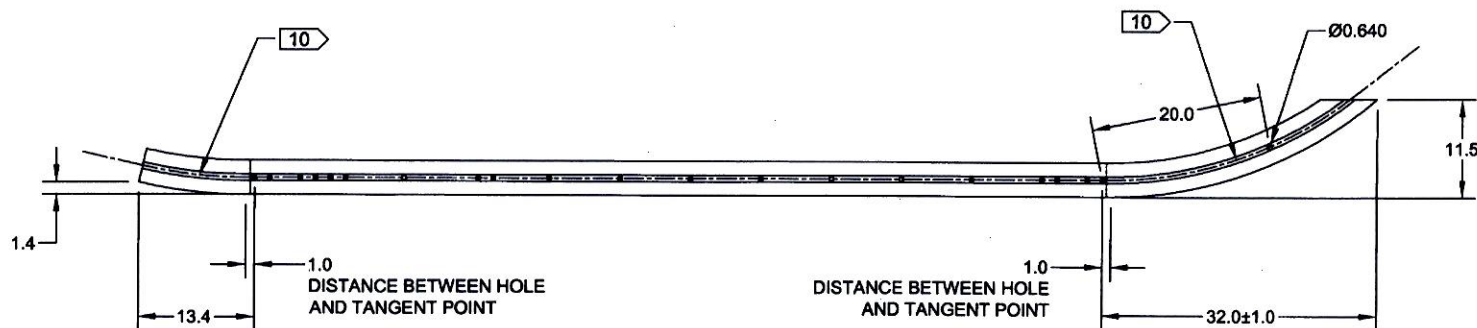
SECTION B-B
SCALE 5X

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002



DETAIL C D3-2
SCALE 5X

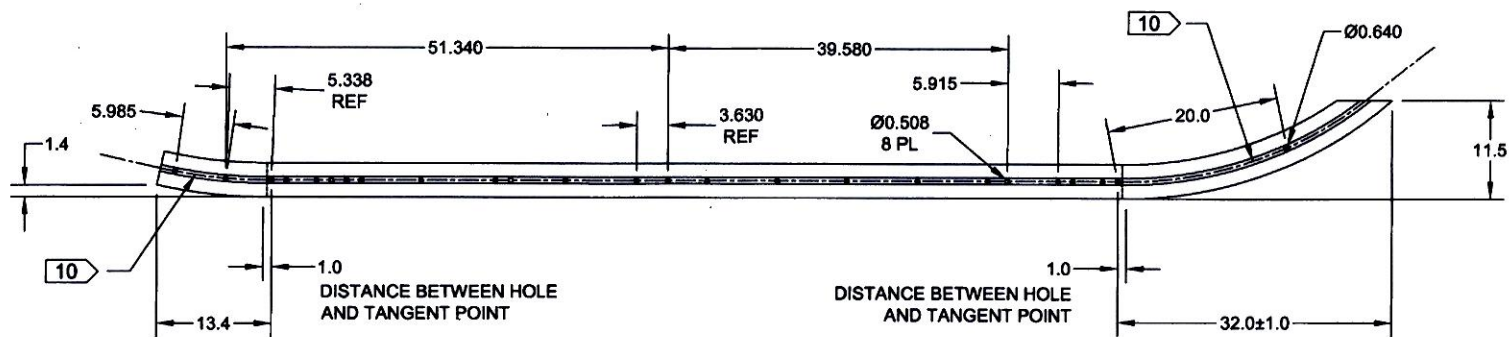
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.		D2580	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		205 SKIDTUBE ASSEMBLY	NTS
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D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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2014-04-29

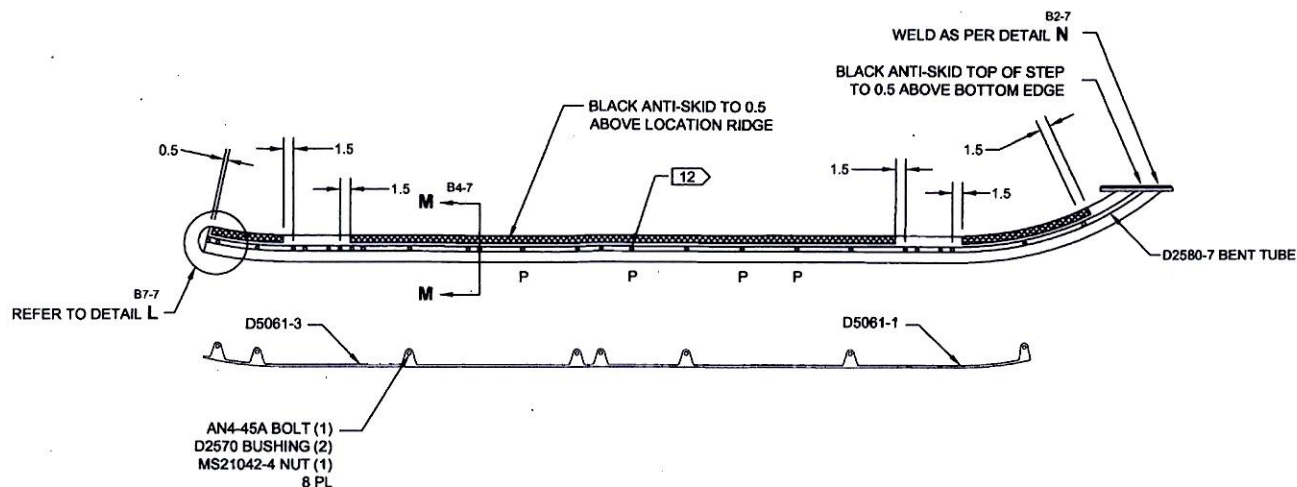
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.		D2580	SHEET 3 OF 9
APPROVED		TITLE	SCALE
DE APPR.		205 SKIDTUBE ASSEMBLY	NTS
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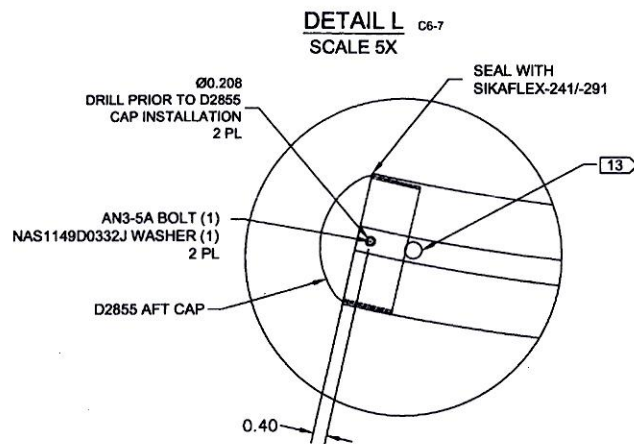
D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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2014-04-29

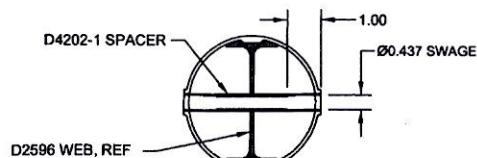
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.L.	DRAWING NO.	REV. G
MFG. APPR.		D2580	SHEET 5 OF 9
APPROVED		TITLE	SCALE
DE APPR.		205 SKIDTUBE ASSEMBLY	NTS
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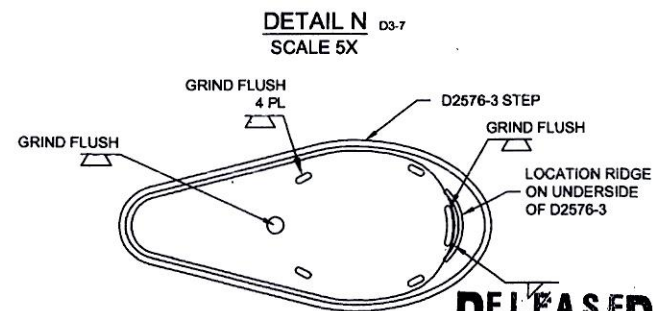
D2580-049 ASSEMBLY DETAIL $\triangle$ G



SECTION M-M D5-7
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002



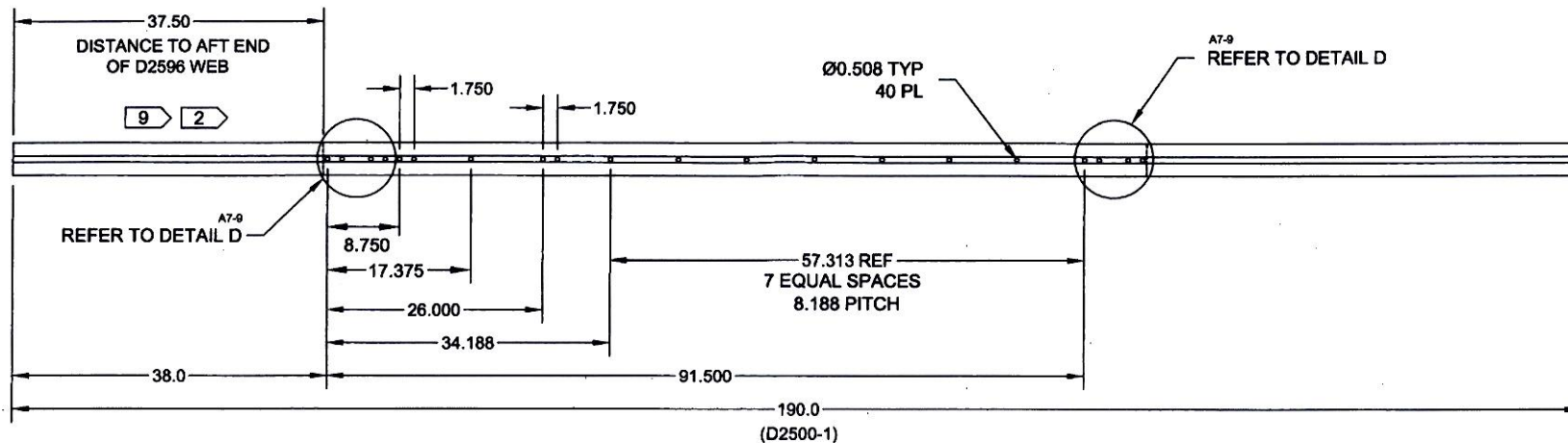
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CHECKED	A.P.	DRAWING NO.	REV. G
MFG. APPR.		D2580	SHEET 7 OF 9
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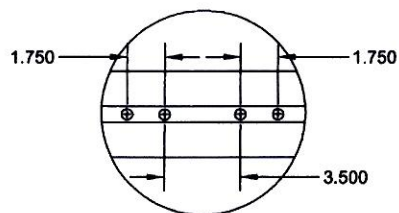


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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>WFO</i>	D2580	SHEET 8 OF 8
APPROVED	<i>WFO</i>	TITLE	SCALE
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D2580-101 TUBE



DETAIL D C3-9
SCALE 5X C7-9

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2014-04-29
WFO

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>[Signature]</i>	D2580	SHEET 9 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
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